

Date: Monday, 3/26/2007 3:00:40 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOWER STEP PROTECTIVE TRIM
Job Number : 31510	
Estimate Number : 12808	
P.O. Number : N/A	Part Number : D36081
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3608 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0001
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <i>[Signature]</i> 07-03-26	Due Date : 4/2/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-03-26 JLM	

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S22GA

304/316 .032 Sheet



Comment: Qty.: 0.7329 sf(s)/Unit Total : 0.7329 sf(s)
 304/316 .032 Sheet
 Batch: *m102159*

ml 07 03 27 (1)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3608
 Dwg Rev: *U/R*
 Prog Rev: *U/R*

ml 07 03 27 (1)

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 28

(1)

4.0

QC8

SECOND CHECK



**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

ml 07 03 28 (1)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3608

N/A

FOR ENGINEERING USE ONLY

ml

Date: Monday, 3/26/2007 3:00:41 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER STEP PROTECTIVE TRIM

Job Number: 31510

Part Number: D36081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NTA

FOR ENGINEERING USE ONLY

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

EC 07.04.03

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EC 07.04.05

Job Completion



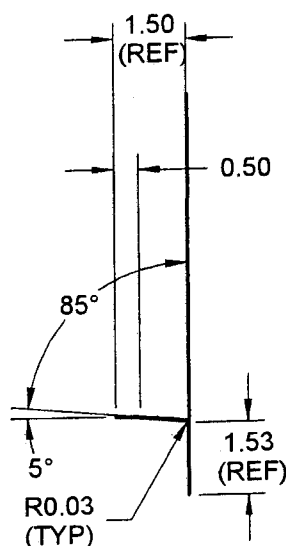
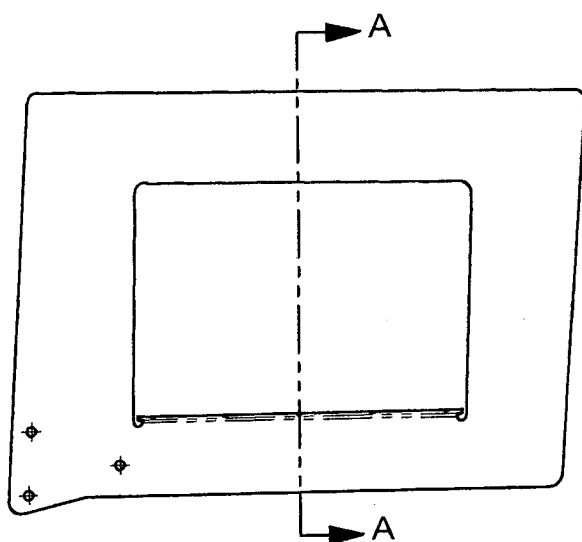
EC 07.04.05

door opener

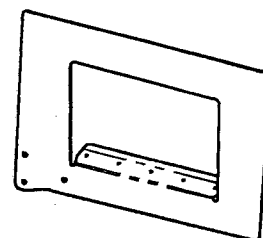
00071

PRELIMINARY ISSUE

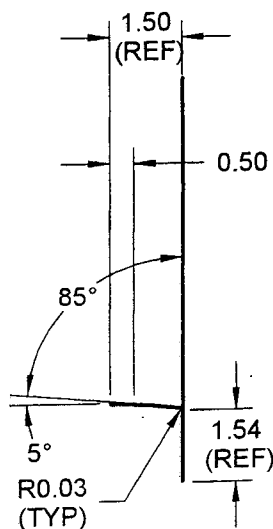
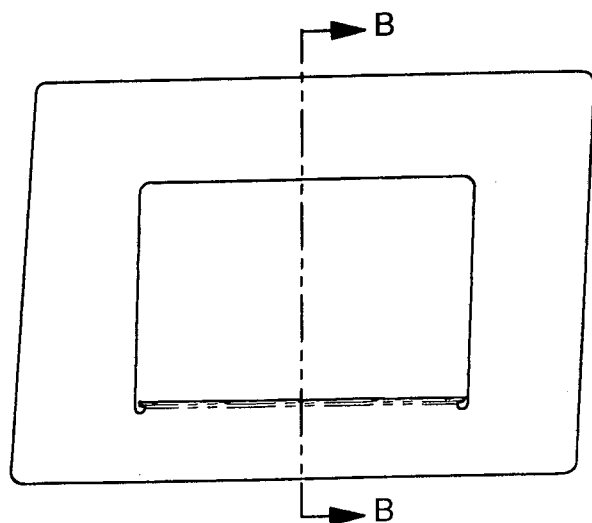
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3608	REV. A SHEET 1 OF 3
DATE 07.03.15	TITLE STEP PROTECTIVE TRIM		SCALE 1:4
REV A	DATE 07.03.15	DESCRIPTION NEW ISSUE	



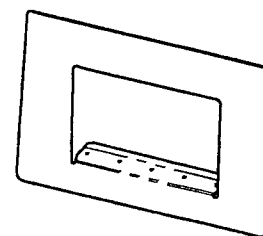
SECTION A-A



**D3608-1 LOWER
STEP PROTECTIVE TRIM
(MAKE FROM D3608-1F)**



SECTION B-B



**D3608-3 UPPER
STEP PROTECTIVE TRIM
(MAKE FROM D3608-3F)**

NOTES:

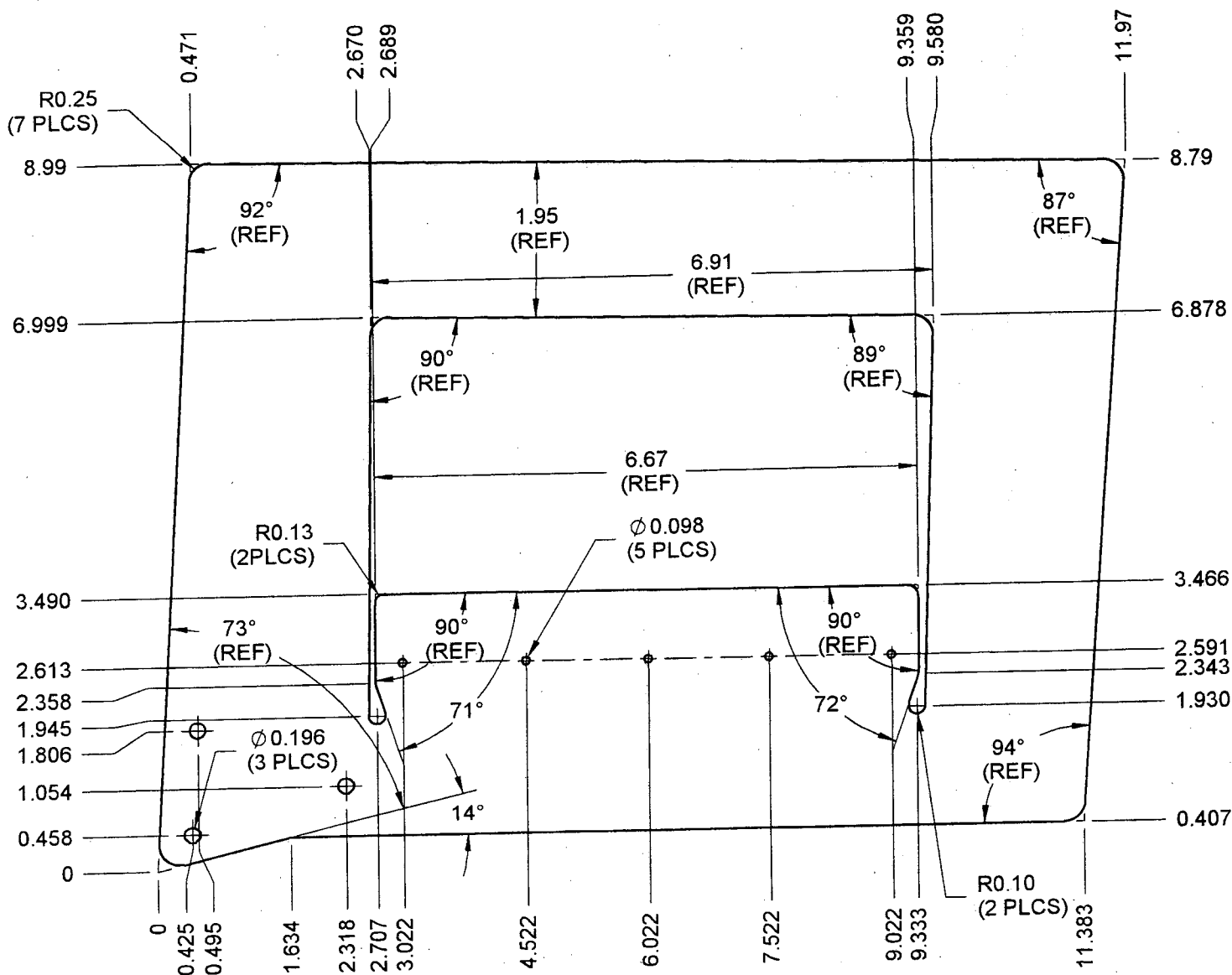
- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH DART P/N D3608-1 OR D3608-3 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 2 OF 3
DATE 07.03.15		TITLE STEP PROTECTIVE TRIM	SCALE 1:2



D3608-1F LOWER STEP PROTECTIVE TRIM

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 24 GAUGE (0.025 THICK)
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.196$	$\pm 0.005-0.001$	0.199	✓		vern	
B 0.032	± 0.010	0.031	✓		vern	
C 6.91	± 0.030	6.912	✓		vern	
D 1.95	± 0.030	1.95	✓		vern	
E R0.25	± 0.030	R0.25	✓		Radius Gauge	
F R0.13	± 0.030	R0.13	✓		Radius Gauge	
G 94°	$\pm 1/2^\circ$	94°	✓		Angle Meter	
H 87°	$\pm 1/2^\circ$	87°	✓		Angle Meter	
I 92°	$\pm 1/2^\circ$	92°	✓		Angle Meter	
J 73°	$\pm 1/2^\circ$	73°	✓		Angle Meter	
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	<i>MM MM</i>
Date:	07.03.28

Audited by:	<i>E</i>
Date:	07.03.28

Prototype Approval:	<i>N/A</i>
Date:	<i>N/A 07.03.28</i>

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	